

D206.628022

Work Order ID 61544

Page 1

Monday, August 30, 2010 11:00:49 AM

Item ID: D2724-042

Accept



Setup Start



Revision ID:

Stop



Item Name: 206L Step Assembly

Start Date: 8/30/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *JP*Date: *10-8-30* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2724

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2724-2 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding*10.09.27**2* *φ*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898
followed by JigA/R AL ROD Batch: *1112360**1114877*

Grind end cap welds flush

*10.10.07**2* *φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.10.07

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/10/07



140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10.10.07

2

W/O:		WORK ORDER CHANGES					
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Work Order ID 61544




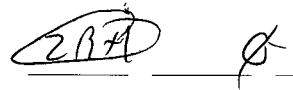


Monday, August 30, 2010 11:00:49 AM



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Item ID: D2724-042 Accept  Setup Start 
Revision ID: Stop 
Item Name: 206L Step Assembly
Start Date: 8/30/2010 Start Qty: 2.00  Cust Item ID:
Required Date: 9/6/2010 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		S 10/10/13					
190  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		=> W 10/10/13					
200  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115291. Memo START TIME: 3:20 OVEN TEMPERATURE: 320° FINISH TIME: 3:50	0.00 0.00		B 10-10-13					

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____




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Monday, August 30, 2010 11:00:49 AM

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Revision ID:						
Item Name:	206L Step Assembly				Stop	
Start Date:	8/30/2010	Start Qty: 2.00		Cust Item ID:		
Required Date:	9/6/2010	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** 
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				X2	Ø		
220 	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
HandFinish Hand Finishing	Memo	0.00				X2	Ø		
230 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

AOP 61545

10/10/18

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/18

10-10-15
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Monday, August 30, 2010 11:00:53 AM

Page 1

Work Order ID: 61544

Parent Item: D2724-042

Parent Item Name: 206L Step Assembly





Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2734  Step End Plate		Manufactured	No			110	Each	27.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				27					
					60216			27					
D3458-1  Step Mounting Plate		Manufactured	No			110	Each	33.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				33					
					51239			3					
					53408			30					
D3458-3  Step Mounting Plate		Manufactured	No			110	Each	16.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				16					
					53409			16					
D2734  Step End Plate		Manufactured	No			160	Each	27.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				27					
					60216			27					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, August 30, 2010 11:00:53 AM

Page 2

Work Order ID: 61544

Parent Item: D2724-042

Parent Item Name: 206L Step Assembly



Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

D2622-120C

Manufactured No

100

Each

55.4200

1

2



Step Extrusion



10-10-07

Location

WA

361208

Loc Qty

55.42

55214

3.42

58544

52

Loc Code

2

W/O:		WORK ORDER CHANGES					
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RETURN TO

ENGINEERING

UNCONTROLLED CONSUMPTION

SUBJECT TO A

WITHOUT

WORK

NO. 61397

PC 10-8-30

DART

REFUSED

2
3
4
5

APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

- REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

D2734 END PLATE

TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622 TYPICAL S
2) WELD PER DART QSI 004 NOT
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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